

Work Order ID 72428

Monday, July 25, 2011 2:35:15 PM



Page 1

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

Stop



Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/08/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch

M114703
M117884

0.00



Large Fab

Memo

0.00

Large Fab

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank; ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5- Weld D4055-7 fwd end

11.08.22 1 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 72428

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| Item ID: D4055-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | |
| Item Name: Fuel Tank Assembly | | | | Stop | |
| Start Date: 7/25/2011 | Start Qty: 1.00 | | Cust Item ID: | | |
| Required Date: 8/8/2011 | Req'd Qty: 1.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 110 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 1 | 0 | | 8E11/08/22 |
| QC Quality Control | Memo | 0.00 | | | | | | | |
| 121 | Weld per dwg A/R Aluminum rod Batch: 117884 114163 | 0.00 | | | | 1 | 0 | | 11-08-23 |
| Large Fab Large Fab | Memo 1-Weld top D4055-1 | 0.00 | | | | | | | |
| 122 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 1 | 0 | | 8E11/08/24 |
| QC Quality Control | Memo | 0.00 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | | | | | |
| | | | | | | | |

*LARGE FAB
Production
Access*

Part No: D4055-041 PAR #: N/A Fault Category: Quality Control NCR: Yes No DQA: A Date: 11.08.30
 Resolution: Re work Disposition: Re work QA: N/C Closed Date: 11/08/31

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|----------|--|--------------------------------|--|--------------------------------|---------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/08/23 | # 123 | After all testing was done During removal of plugs D4000-5 tank vent was stripped. R.C. no focus | | Cut + Remove D4000-5 + SCRAP | <i>[Signature]</i> 11.08.23 | | | <i>[Signature]</i> 11/08/23 |
| | | | | Re weld as per Dwg + QSI on new D4000-5 | <i>[Signature]</i> 11.08.23 | | | |
| | | (Plugs were good, had teller tape. no way of stopping this from happening.) | <i>[Signature]</i> 11/08/23 | B 72427 Qty x1 N/A 117884 | <i>[Signature]</i> 11.08.23 | | <i>[Signature]</i> 11/08/23 | <i>[Signature]</i> 11/08/23 |
| | | | | | | | | |

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Item ID: D4055-041

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Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

Stop



Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Mask prior to powdercoat

Start Time: _____

Oven Temperature: _____

Finish Time: _____

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

185



SprayPaint

Spray Painting

Memo

0.00

Seal inside of tank using Sloshing

PR-1005-L

Sealer as per dwg

M 118533

1-08-26 051042

PS 311 H3

1000 320 01- 1:30

IX M 11/08/24

1 BR 11-8-25..

1 BR 11-8-25.

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| Item ID: | D4055-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Fuel Tank Assembly | | | | | |
| Start Date: | 7/25/2011 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 8/8/2011 | Req'd Qty: | 1.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------|---------------------|------|--|--|--|--|--|--|--|
| 190 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Assemble as per dwg | | | | | | | | |

Handwritten: 8/5/08/26 (D)

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 200 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Handwritten: 5/10/08/26

Handwritten: (D)

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 220 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Handwritten: n/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

APP 72517

11/8/26 8

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29

ME 11-08-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72428

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
 10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
 revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055
 revB EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3997-1 Placard | | Manufactured | No | | | 190 | Each | 6.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>ST104</div> <div>68930</div> <div>71177</div> </div> <div> <div>Loc Qty</div> <div>1/6</div> <div>2</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| D3997-5 Placard | | Manufactured | No | | | 190 | Each | 8.0000 | 2 | 2 | | | |
| <div> <div>Location</div> <div>ST104</div> <div>71170</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| D3997-11 Placard | | Manufactured | No | | | 190 | Each | 5.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>ST104</div> <div>65124</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| D3997-17 Placard | | Manufactured | No | | | 190 | Each | 5.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>ST104</div> <div>65125</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> | | | | | | | | | | | | | |

EPB/08/06

EPB/08/06
372611 (2x)

EPB/08/06
B72614 (1x)

EPB/08/06
B72617 (1x)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72428

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190 Each

5.0000



Placard

Location

Loc Qty

Loc Code

ST104

5

65126

5

D3997-43

Manufactured No

190 Each

4.0000



Placard

Location

Loc Qty

Loc Code

ST104

4

65127

4

D3999-7

Manufactured No

100 Each

1.0000



Corner

Location

Loc Qty

Loc Code

ENG

1

55645

1

D3999-9

Manufactured No

100 Each

0.0000



Angle

D3999-11

Manufactured No

100 Each

0.0000



Earth Tab

D3999-041

Manufactured No

100 Each

2.0000



Baffle Assembly, Aft

Location

Loc Qty

Loc Code

WA014

2

70248

2

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|--------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72428

Parent Item: D4055-041













Parent Item Name: Fuel Tank Assembly

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | | | |
|--|--------------|----|----------------------|-----|----------------|---------|-----------------|---|---|---------------------------|
| ✓ D3999-043 | Manufactured | No | | 100 | Each | 2.0000 | 1 | 1 |  | <u>11.08.11</u> |
|  | | | | | | | | | | |
| Baffle Assembly, Fwd | | | | | | | | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA014 | | 2 | | | | | |
| | | | 70249 | | 2 | | | | | |
| ✓ D4000-1 | Manufactured | No | | 100 | Each | 2.0000 | 1 | 1 |  | <u>11.08.04</u> |
|  | | | | | | | | | | |
| Fuel Supply Fitting | | | | | | | | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA013 | | 2 | | | | | |
| | | | 65716 | | 2 | | | | | |
| ✓ D4000-5 | Manufactured | No | | 100 | Each | 0.0000 | 1 | 1 |  | <u>11.08.22 B 72427 ①</u> |
|  | | | | | | | | | | |
| Fuel Tank Vent Fitting | | | | | | | | | | |
| ✓ D4000-9 | Manufactured | No | | 100 | Each | 10.0000 | 3 | 3 |  | <u>11.08.15</u> |
|  | | | | | | | | | | |
| Grommet | | | | | | | | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA013 | | 10 | | | | | |
| | | | 70250 | | 10 | | | | | |
| ✓ D4000-043 | Manufactured | No | | 100 | Each | 0.0000 | 1 | 1 |  | <u>11.08.15 B 71697</u> |
|  | | | | | | | | | | |
| Drain Fitting Assembly, Fwd | | | | | | | | | | |
| ✓ D4000-045 | Manufactured | No | | 100 | Each | 3.0000 | 1 | 1 |  | <u>11.08.22</u> |
|  | | | | | | | | | | |
| Fuel Pickup Fitting Assembly | | | | | | | | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA 311698 | | 3 | | | | | |
| | | | 71669 | | 3 | | | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID: 72428

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-041

Manufactured No

100

Each

0.0000

1

1



Drain Fitting Assembly, Aft

D4001-1

Manufactured No

100

Each

1.0000

1

1



Fitting

11.08.15 B72793

11.08.22 B71698 (1)

Location

Loc Qty

Loc Code

WA013

1

66840

1

✓ D4008-11

Manufactured No

100

Each

7.0000

1

1



Hinge Half

11.08.16

Location

Loc Qty

Loc Code

ST108

7

65445

3

67650

4

D4008-041

Manufactured No

190

Each

5.0000

1

1



Fuel Filler Splash Guard Assembly

11/08/26

B72200 (1)

Location

Loc Qty

Loc Code

ST108

5

70140

5

D4023-3

Manufactured No

100

Each

4.0000

1

1



Cap and Flange

11.08.11

Location

Loc Qty

Loc Code

WA

4

70204

4

1

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:35:23 PM

Page 5

Work Order ID: 72428

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4025-1 Manufactured No 100 Each 3.0000



Fuel Quantity Sender



8/11/08/26
B71765 (IX)

Location Loc Qty Loc Code

ST142 3
69502 3

D4055-11 Manufactured No 100 Each 8.0000



Tank Front and Bottom



8/11-08.11

Location Loc Qty Loc Code

WA 3
70201 3
WA013 5
65447 2
68500 3

D4055-9 Manufactured No 100 Each 3.0000



Tank Back



8/11-08.11

Location Loc Qty Loc Code

WA013 3
63948 1
65451 1
66842 1

D4055-7 Manufactured No 100 Each 2.0000



Tank Fwd End



8/11-08.22

Location Loc Qty Loc Code

WA014 *B71700* 2
65450 1
70251 1

Monday, July 25, 2011 2:35:23 PM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:35:23 PM

Page 6

Work Order ID: 72428

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4055-5 Tank Upper Cut Out

| | | | | | | | | |
|--------------|----|-----|------|--------|---|---|---|-----------------|
| Manufactured | No | 100 | Each | 3.0000 | 1 | 1 |  | <u>11.08.15</u> |
|--------------|----|-----|------|--------|---|---|---|-----------------|


✓ D4055-3 Tank Aft End

| | | | | | | | | |
|--------------|----|-----|------|--------|---|---|---|-----------------|
| Manufactured | No | 100 | Each | 2.0000 | 1 | 1 |  | <u>11.08.04</u> |
|--------------|----|-----|------|--------|---|---|---|-----------------|

* D4055-1 Tank Top

| | | | | | | | | |
|--------------|----|-----|------|--------|---|---|---|-----------------|
| Manufactured | No | 100 | Each | 1.0000 | 1 | 1 |  | <u>11.08.02</u> |
|--------------|----|-----|------|--------|---|---|---|-----------------|

✓ D4057-1 Retaining Ring

| | | | | | | | | |
|--------------|----|-----|------|---------|---|---|---|-----------------|
| Manufactured | No | 100 | Each | 44.0000 | 3 | 3 |  | <u>11.08.15</u> |
|--------------|----|-----|------|---------|---|---|---|-----------------|

Location Loc Qty Loc Code

WA013 3

67737 3

Location Loc Qty Loc Code

WA 1

68501 1

WA014 1

70447 1

Location Loc Qty Loc Code

WA013 1

65446 1

Location Loc Qty Loc Code

WA013 44

55826 8

71166 36

Monday, July 25, 2011 2:35:23 PM

Shop Packet Print

Page 6

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:35:23 PM

Work Order ID: 72428

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN3H5A

Purchased

No

190

Each

57.0000

5

5



Bolt

Location

Loc Qty

Loc Code

ST350

7

116704

7

ST351

50

118112

50

NAS1149D0363J

Purchased

No

190

Each

2,780.000

5

5



Washer

Location

Loc Qty

Loc Code

ST298

2780

117505

410

117601

370

118077

2000

D4404-1

Manufactured

No

190

Each

6.0000

1

1



Cushion

Location

Loc Qty

Loc Code

ST404

6

70247

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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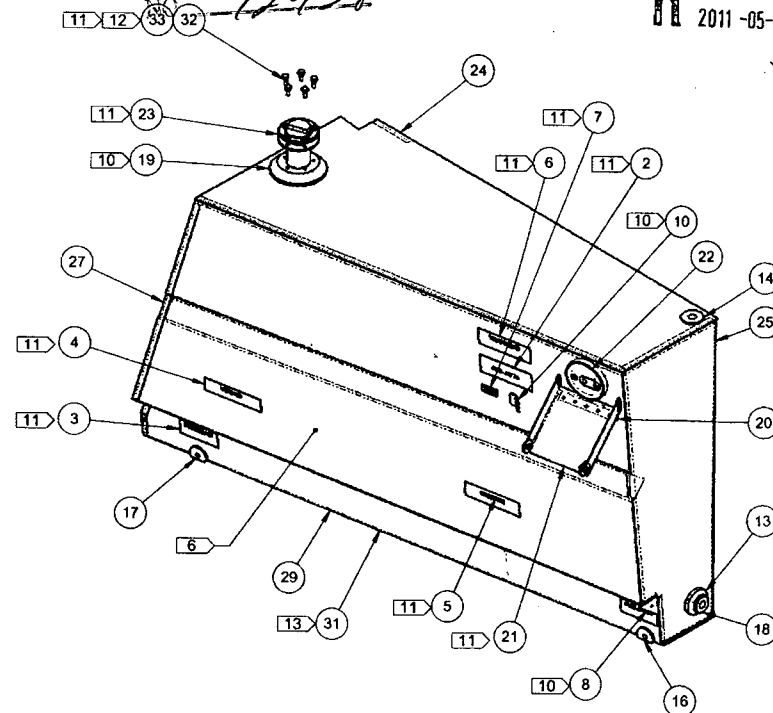
NOTE: Date & initial all entries

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RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER 22426

RELEASED
2011-05-30

| ITEM NO. | QTY. .041 | PART NUMBER | DESCRIPTION |
|----------|--------------|---------------|------------------------------------|
| 1 | X | D4055-041 | FUEL TANK ASSEMBLY |
| 2 | 1 | D3997-1 | PLACARD "FUEL JET A1" |
| 3 | 2 | D3997-5 | PLACARD "AUX FUEL DRAIN" |
| 4 | 1 | D3997-11 | PLACARD "LOADING" |
| 5 | 1 | D3997-17 | PLACARD "STOWAGE" |
| 6 | 1 | D3997-29 | PLACARD "WARNING" |
| 7 | 1 | D3997-43 | PLACARD "EARTH" |
| 8 | 1 | D3999-7 | CORNER |
| 9 | 1 | D3999-9 | ANGLE |
| 10 | 1 | D3999-11 | EARTH TAB |
| 11 | 1 | D3999-041 | BAFFLE ASSEMBLY, AFT |
| 12 | 1 | D3999-043 | BAFFLE ASSEMBLY, FWD |
| 13 | 1 | D4000-1 | FUEL SUPPLY FITTING |
| 14 | 1 | D4000-5 | FUEL TANK VENT FITTING |
| 15 | 3 | D4000-9 | GROMMET |
| 16 | 1 | D4000-041 | AFT FUEL SUMP DRAIN ASSEMBLY |
| 17 | 1 | D4000-043 | FORWARD FUEL SUMP DRAIN ASSEMBLY |
| 18 | 1 | D4000-045 | FUEL PICK UP AND STRAINER ASSEMBLY |
| 19 | 1 | D4001-1 | FITTING |
| 20 | 1 | D4008-11 | TANK HINGE HALF |
| 21 | 1 | D4008-041 | FUEL FILLER SPLASH GUARD ASSEMBLY |
| 22 | 1 | D4023-3 | FUEL CAP |
| 23 | 1 | D4025-1 | FUEL SENDER |
| 24 | 1 | D4055-1 | TANK TOP |
| 25 | 1 | D4055-3 | TANK AFT END |
| 26 | 1 | D4055-5 | TANK UPPER CUT OUT |
| 27 | 1 | D4055-7 | TANK FORWARD END |
| 28 | 1 | D4055-9 | TANK BACK |
| 29 | 1 | D4055-11 | TANK FRONT AND BOTTOM |
| 30 | 3 | D4057-1 | RETAINING RING |
| 31 | 1 | D4404-1 | CUSHION |
| 32 | 5 | AN3H5A | BOLT |
| 33 | 5 | NAS1149D0363J | WASHER |



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY

| | | |
|--|---|---------------|
| B | MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS | 11.05.12 |
| A | NEW ISSUE | HS 10.04.16 |
| REV. | DESCRIPTION | BY DATE |
| DESIGN | | |
| DRAWN | | |
| CHECKED | | |
| MFG. APPR. | | |
| APPROVED | | |
| DE APPR. | | |
| DATE | 11.05.12 | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWING NO. D4055 | | REV. B |
| TITLE TANK | | SHEET 1 OF 15 |
| SCALE NTS | | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

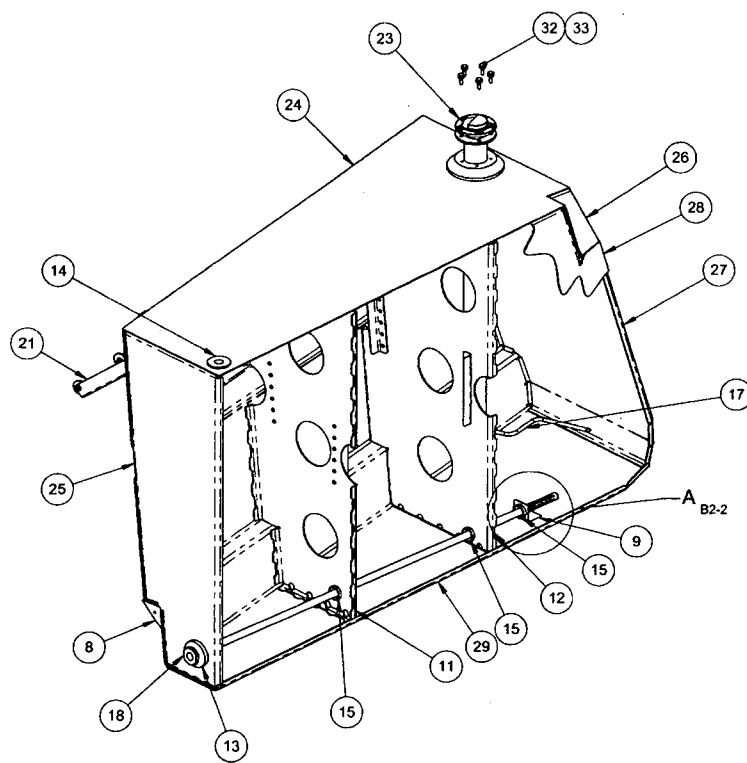
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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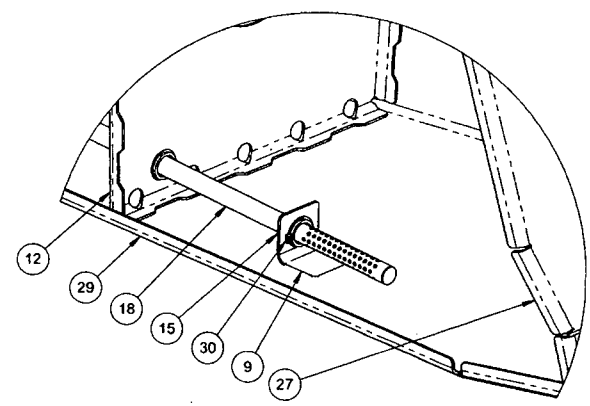
NOTE: Date & initial all entries

72428

RELEASED
2011-05-30
MD



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

| | | | |
|------------|--------------------|---|---------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4055 | SHEET 2 OF 15 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TANK | NTS |
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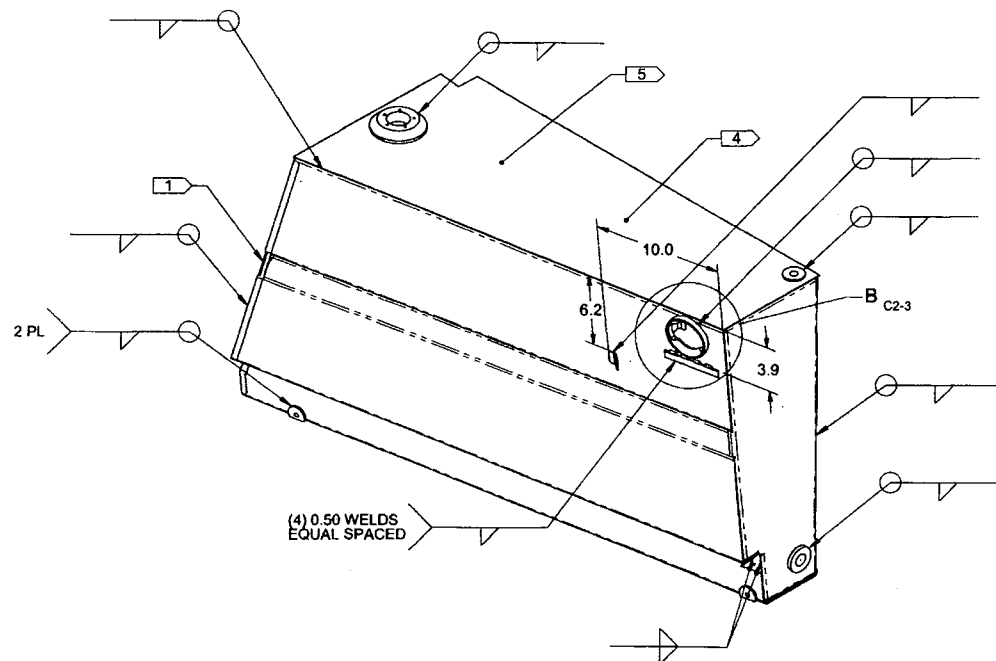
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

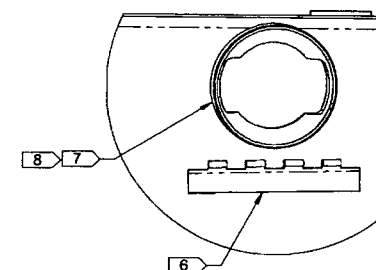
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

C4-3

RELEASED
2011-05-30

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.80 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

| | | | |
|------------|----------|--|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 3 OF 15 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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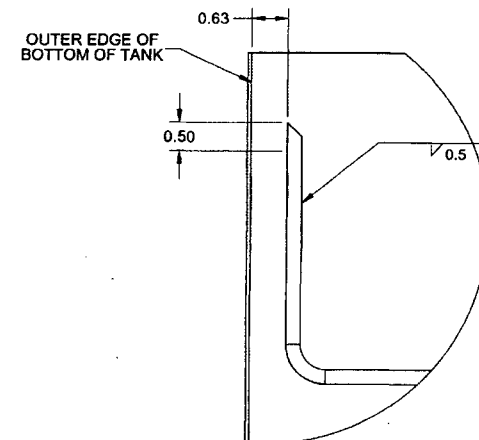
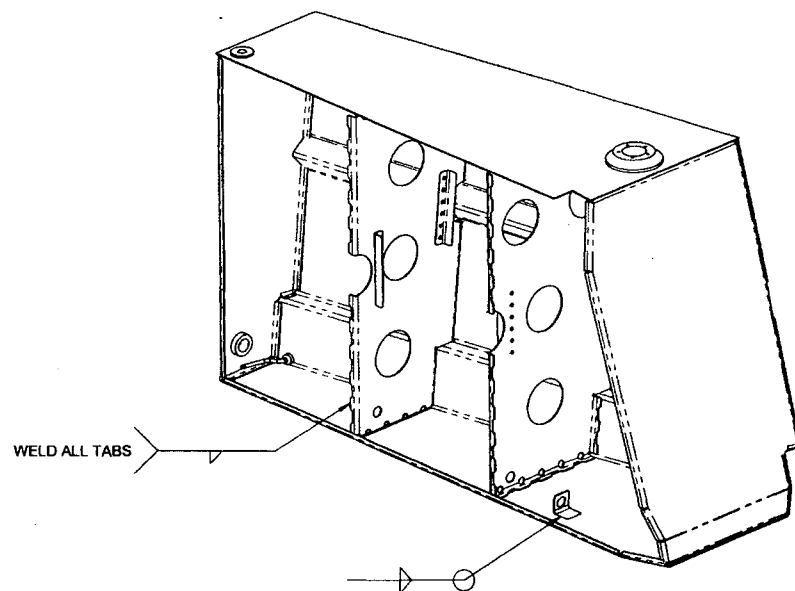
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

72428



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

RELEASED
 2011-05-30
 JNN

| | | | |
|------------|--------------------|---|---------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4055 | SHEET 4 OF 15 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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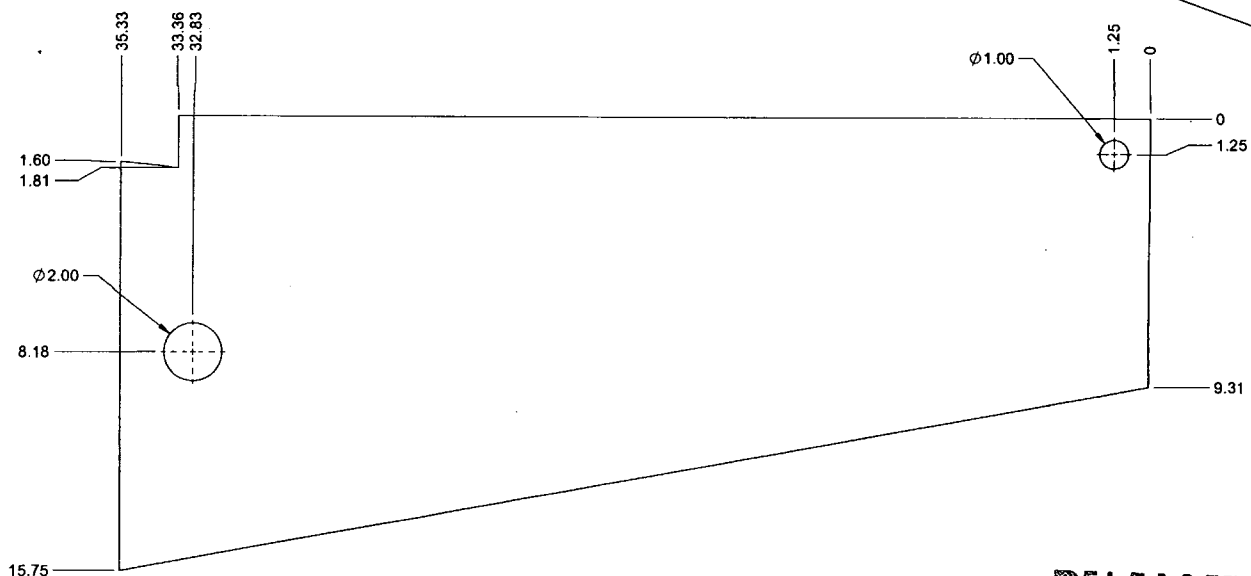
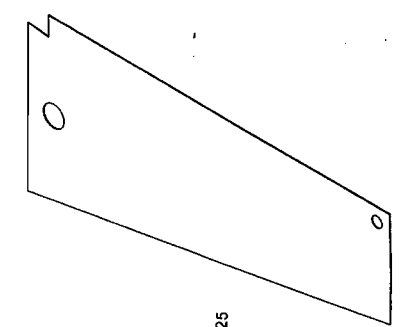
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NOTE: Date & initial all entries

72428



0.063
REF

D4055-1 TANK TOP

RELEASED
 2011-05-30
 JWB

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027 OR ASTM B209
 REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs



| | | | |
|------------|----------|---|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4055 | REV. B |
| MFG. APPR. | | TITLE | SHEET 5 OF 15 |
| APPROVED | | TANK | SCALE |
| DE APPR. | | | NTS |
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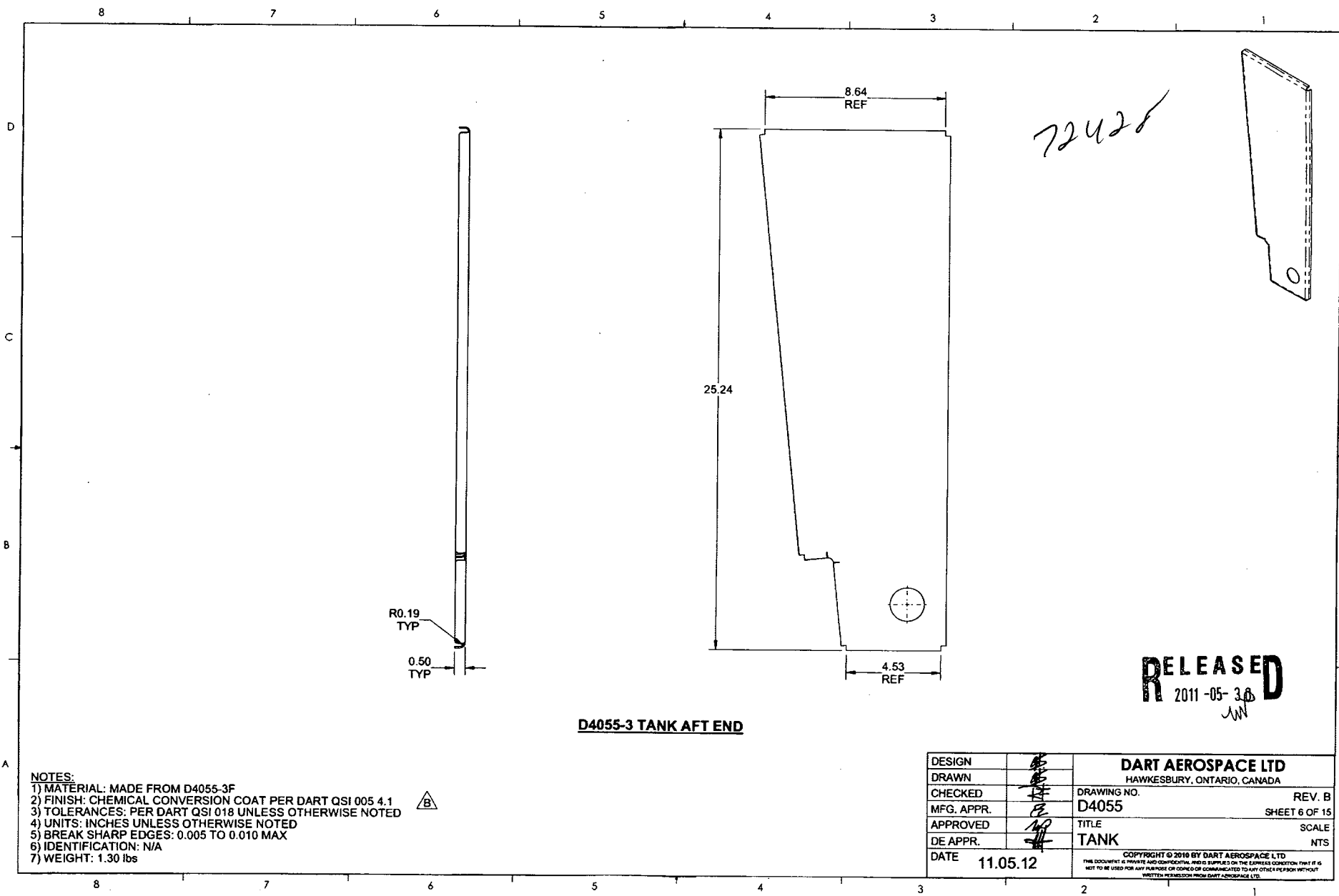
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D4055-3 TANK AFT END

NOTES:

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs



| | | | |
|------------|----------|--|---------------|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 6 OF 15 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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2011-05-30
JUN

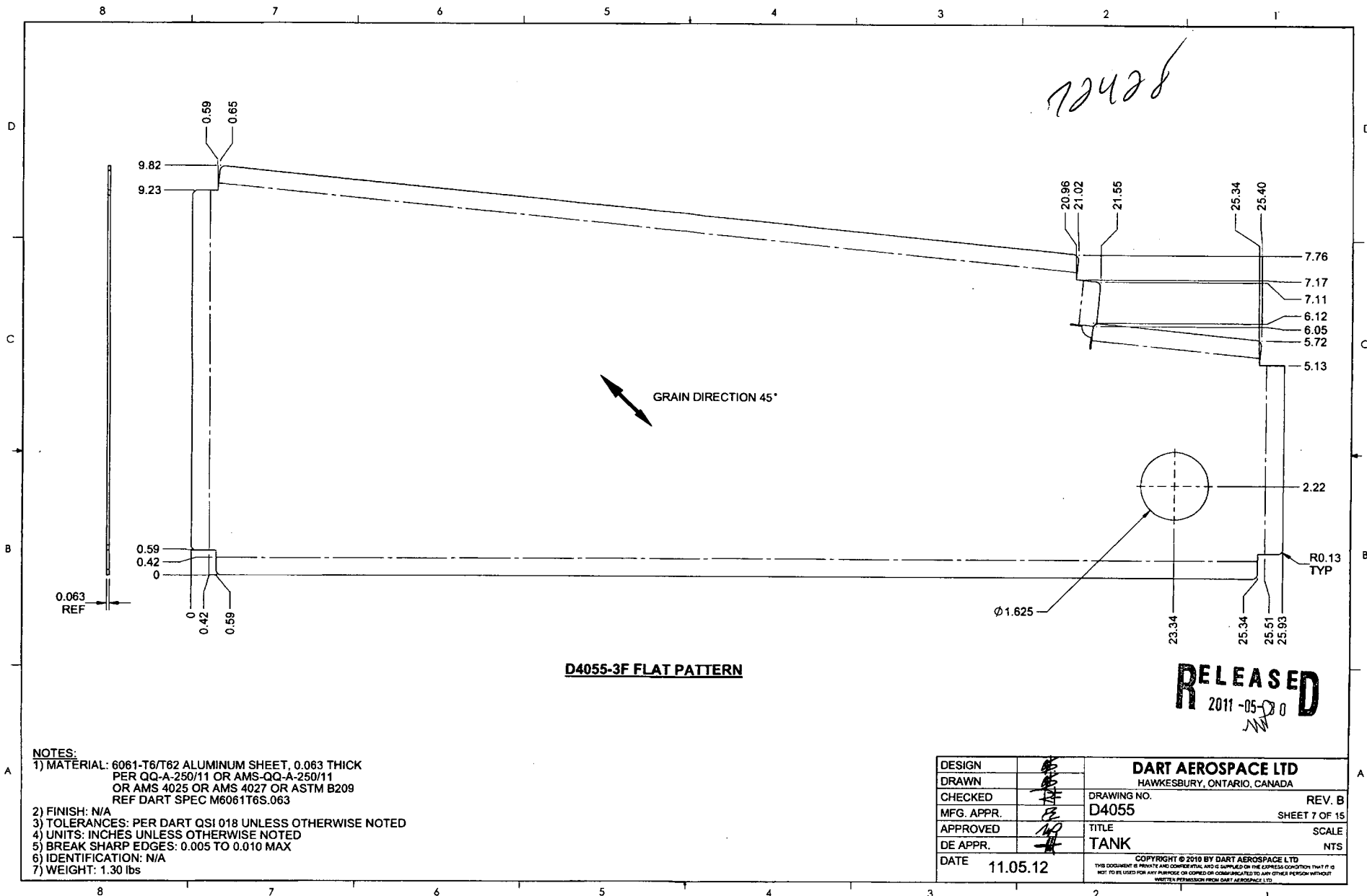
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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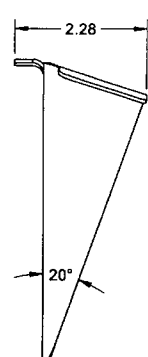
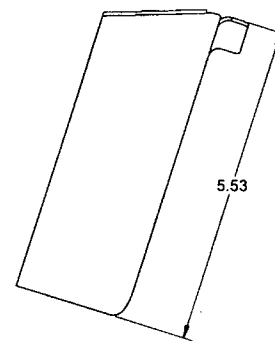
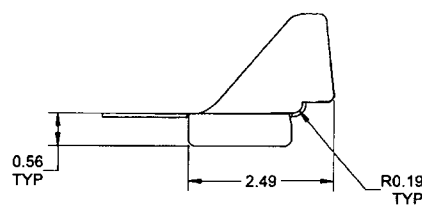
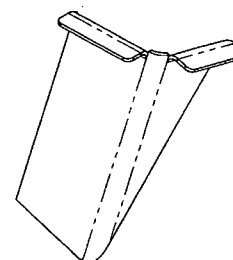
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

72426



D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
ANN

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs



| | | | |
|------------|--------------------|--|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4055 | SHEET 8 OF 15 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TANK | NTS |
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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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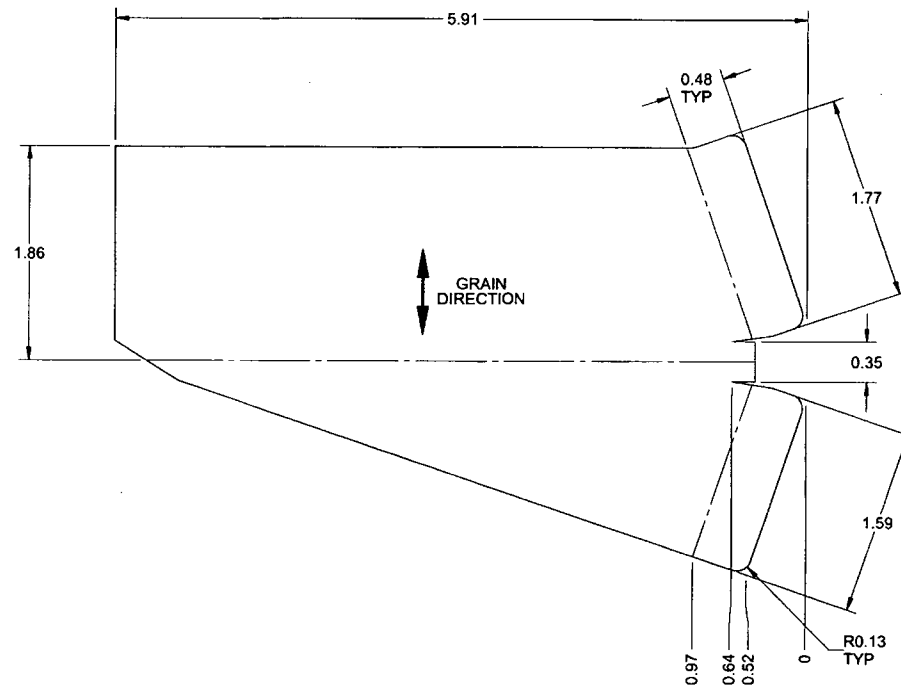
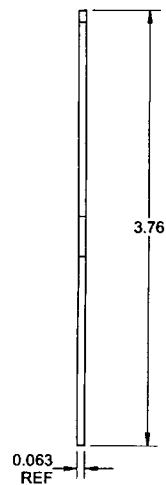
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

72428



D4055-5F FLAT PATTERN

RELEASED
2011-05-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

| | | | |
|------------|-----------------|---|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 9 OF 15 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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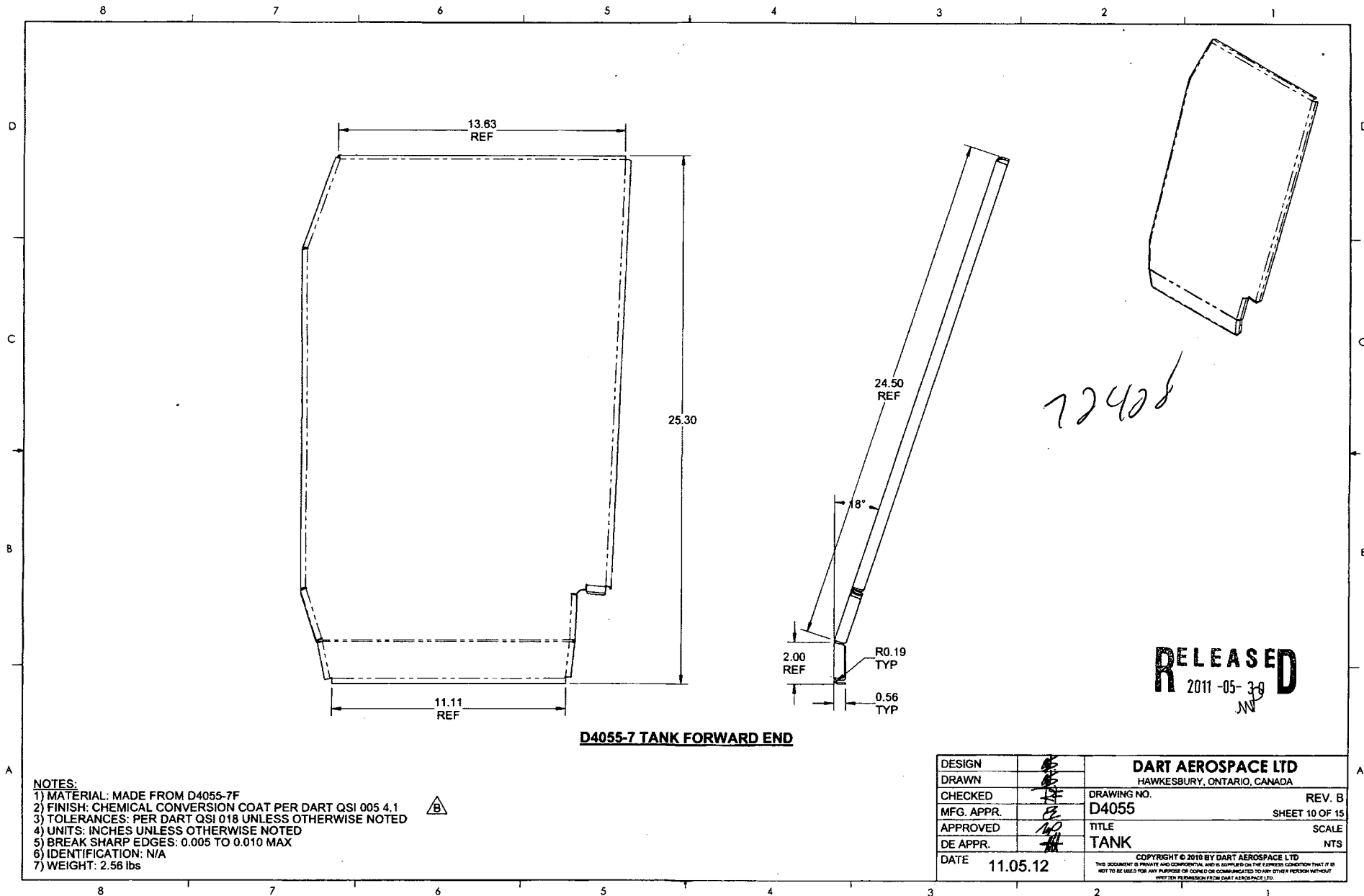
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

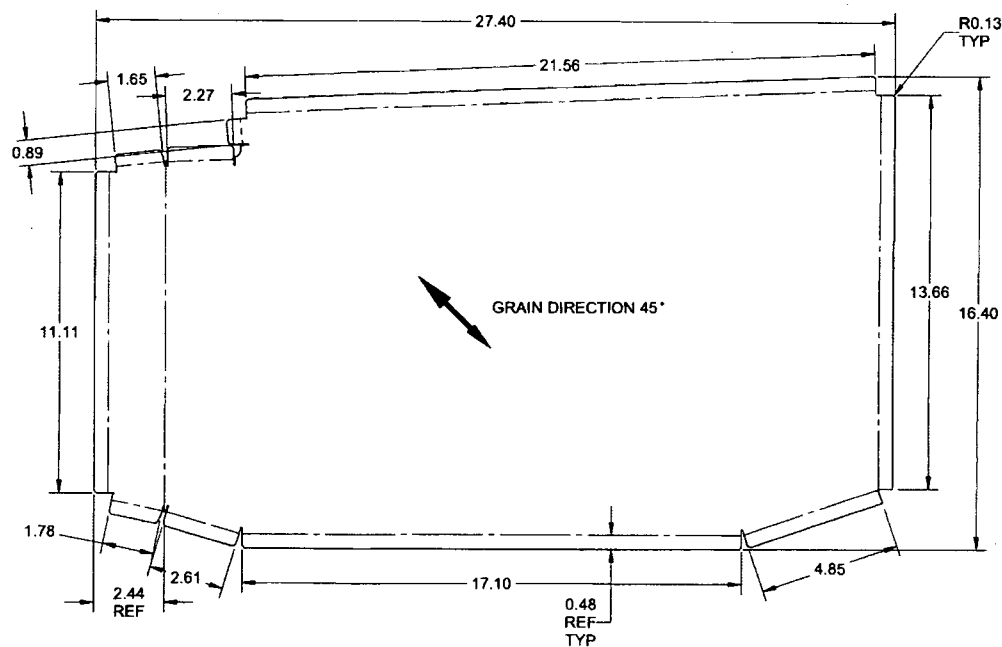
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

72428

0.063
REF



D4055-7F FLAT PATTERN

RELEASED
2011-05-30
AW

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

| | | | |
|------------|----------|--|----------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 11 OF 15 |
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| DE APPR. | | TANK | NTS |
| DATE | 11.05.12 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

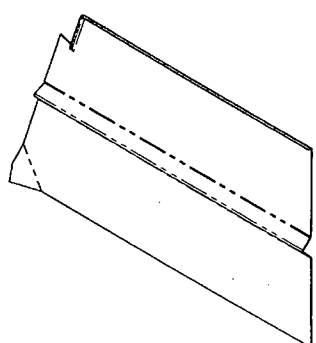
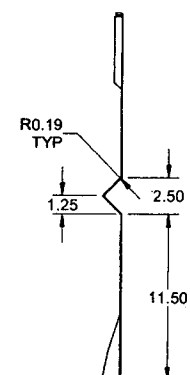
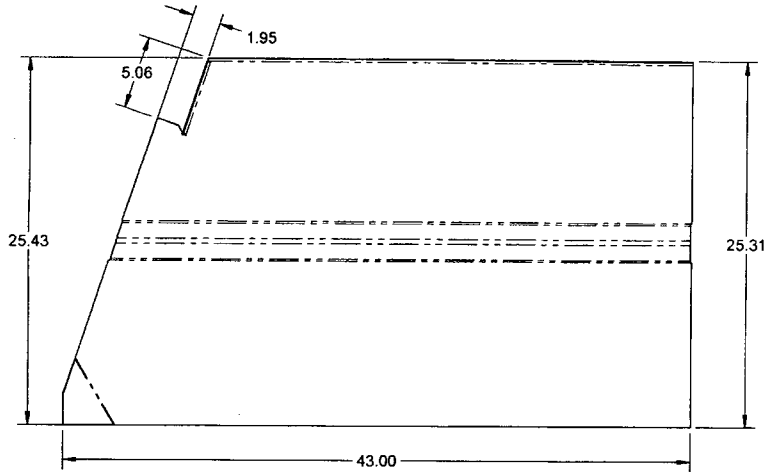
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



72428

D4055-9 TANK BACK

RELEASED
2011-05-30

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



| | | | |
|--|----------|--|----------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 12 OF 15 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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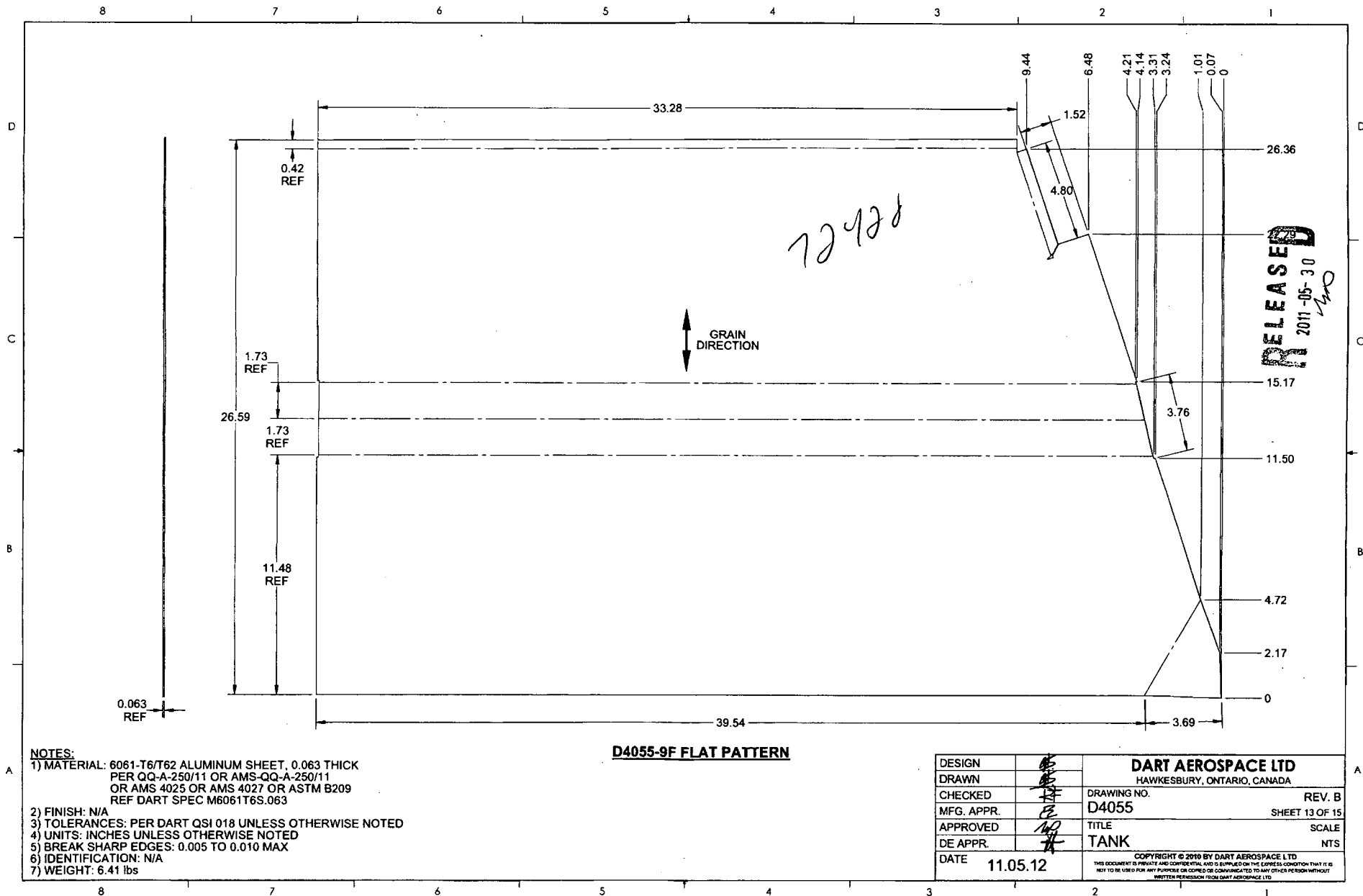
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



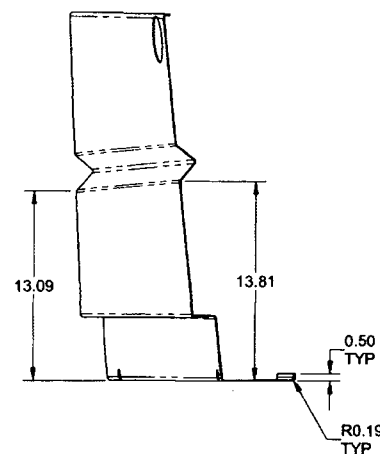
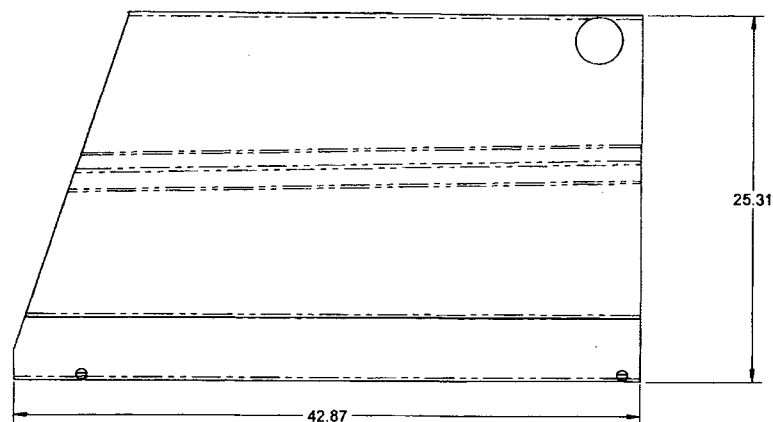
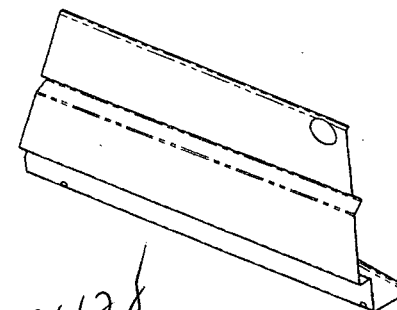
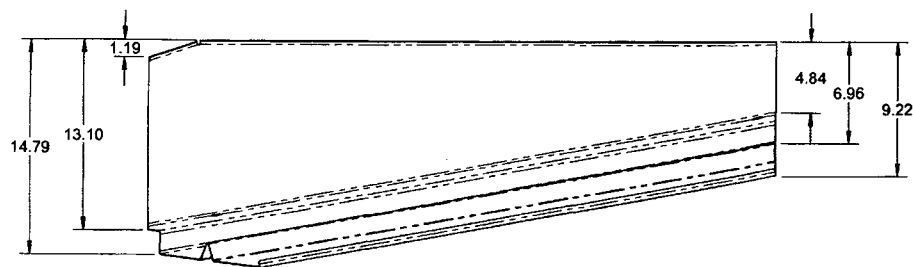
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D4055-11 TANK FRONT AND BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



| | | | | |
|--|-----------------|--|--------------------------|---------------|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | | | | |
| CHECKED | | | DRAWING NO. D4055 | REV. B |
| MFG. APPR. | | | SHEET 14 OF 15 | |
| APPROVED | | | TITLE | SCALE |
| DE APPR. | | | TANK | NTS |
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2011-05-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

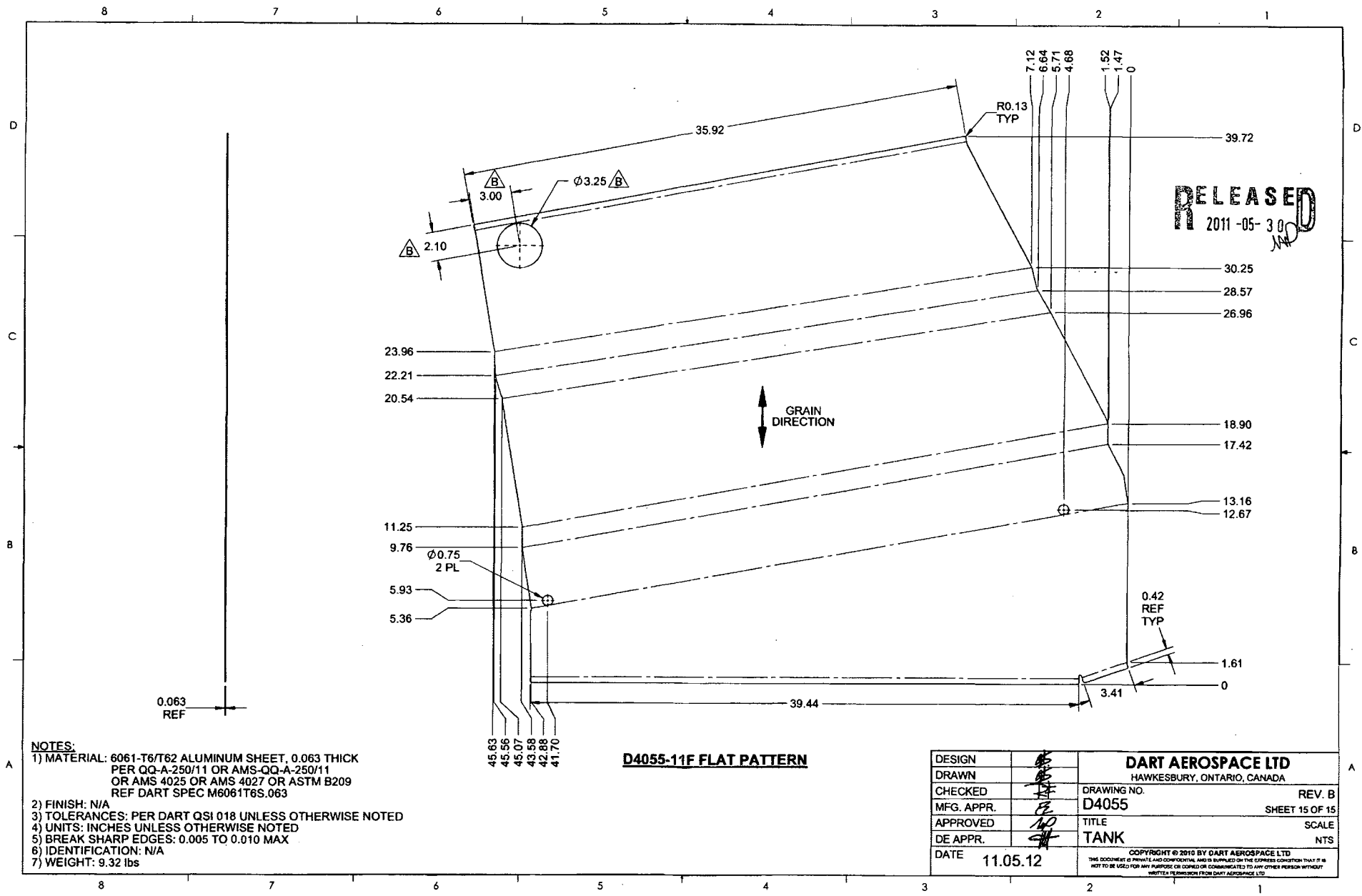
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries






72422

RELEASED
2011-05-30



- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs

D4055-11F FLAT PATTERN

| | | | |
|------------|---|---|----------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 15 OF 15 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | TANK | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries